



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5556-041
Job Sheet 178660



Part No: D5556-041

Job Qty: 1 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/5/18

Job Tracking No: RD17-1046-01

Due Date: 6/8/18

Created By: Linda Lacelle

Type: R+D

Description:

Note: TBD D5556 REV.A IPP REV:A 18.02.02 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/8/18	0.00	0.00	Start Up Small Fab-4		JUN 08 2018
110	Small Fab	1 pcs		6/8/18	0.00	0.43	Small Fab-3		5040 18-06-11
120	QC	1 pcs		6/8/18	0.00	0.00	QC5		OK 18-6-11
130	Packaging	1 pcs		6/8/18	0.00	0.00	Packaging3-2		7/10
140	QC21-SA	1 Ea		6/8/18	0.00	0.00	QC21		JUN 11 2018

Part Op 110 - ASSEMBLE AS PER DWG AND APPLY RTV TO ALL FAYING SURFACES RTV 598 BATCH: 5068314

Descriptions:

CC1019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5557-1	Cutter Blade	2 Ea (2 ea)	90-Start up Operation	5044571
D5573-1	Base Bracket, Upper, Cable Cutter, LH	1 Ea (1 ea)	90-Start up Operation	5078457
D5573-2	Base Bracket, Upper, Cable Cutter, RH	1 Ea (1 ea)	90-Start up Operation	5078457
D5574-1	Blade Housing, Cable Cutter	1 Ea (1 ea)	90-Start up Operation	5048130
D5576-1	Deflector, Upper, Cable Cutter	1 Ea (1 ea)	90-Start up Operation	5049637
MS21042L08	Nut	10 Ea (10 ea)	90-Start up Operation	5044234
MS27039-08-20	Screw	6 Ea (6 ea)	90-Start up Operation	5070334
MS27039-08-24	Screw (MS27039-0824)	4 Ea (4 ea)	90-Start up Operation	5054100
NAS1149DN832J	Washer	20 Ea (20 ea)	90-Start up Operation	5034111

MS27039-08-19

6 ea 5044235

Job Allocations

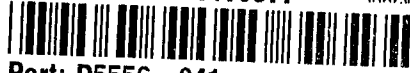
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5557-1	2	16	0
	D5573-1	1	3	0
	D5573-2	1	2	0
	D5574-1	1	1	0
	D5576-1	1	1	0
	MS21042L08	10	1,605	0
	MS27039-08-20	6	88	0
	MS27039-08-24	4	109	0
	NAS1149DN832J	20	1,864	0

503257



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5290
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S079377



Part: D5556-041

Job No: 178660

Serial No/Batch: S079377

Revision: A

Inspector:

Instructions:

Date: 06/08/18

Entered: _____ Date: _____



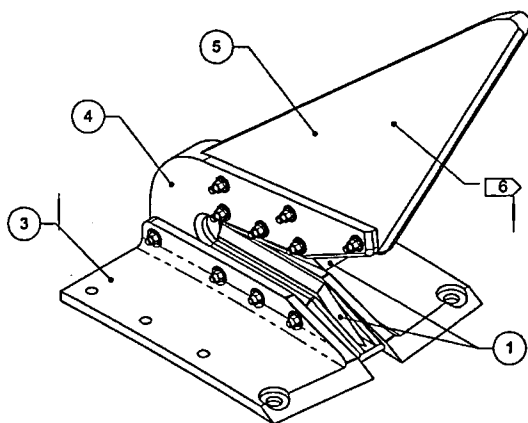
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☒

Job: <u>178660</u> Part No. <u>D5556041</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>18/6/8</u>	Sequence #: <u>110</u>	QTY Affected: <u>1</u>		MRB (QSI042) <u>INSP 12 9/14/40</u>	
Description Work Order Deviation * Substitute ms 27039-08-20 to ms 27039-08-19, reason ^{Screw} was too long had 5 thread, it Should be 3 thread max <i>work order update</i>		Disposition Acceptable. Minor change to ensure proper number of threads in safety		Completed By <u>SAN 18-06-08</u> Lead hand / Supervisor <u>SB</u> <u>18/06/14</u> QC / QA Coordinator <u>5 18/6/14</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5556-041	UPPER CUTTER ASSEMBLY
1	2	D5557-1	CUTTER BLADE
2	1	D5573-1	BASE BRACKET, UPPER, CABLE CUTTER (LH)
3	1	D5573-2	BASE BRACKET, UPPER, CABLE CUTTER (RH)
4	1	D5574-1	BLADE HOUSING, CABLE CUTTER
5	1	D5576-1	DEFLECTOR, UPPER, CABLE CUTTER
6	10	MS21042L08	NUT, SELF-LOCKING
7	4	MS27039-0824	SCREW, PAN HEAD
8	6	MS27039-0820	SCREW, PAN HEAD
9	20	NAS1149DN832J	WASHER (AN960JD8)



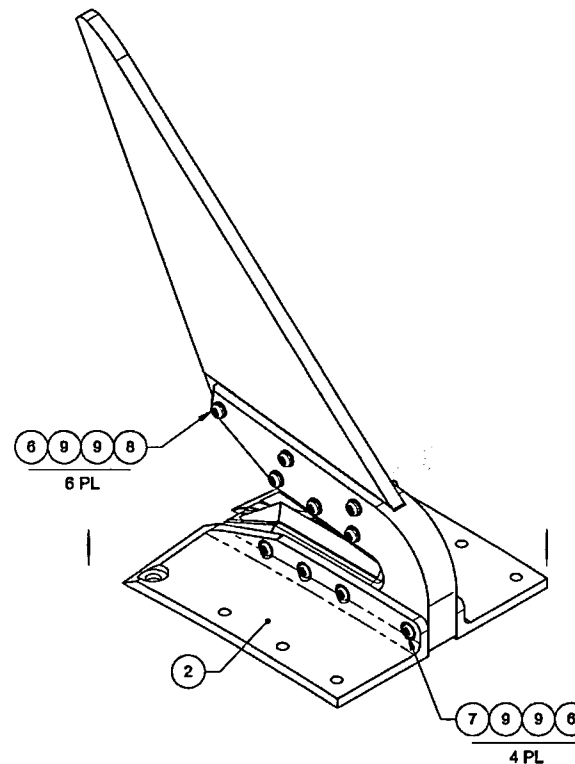
D5556-041 UPPER CUTTER ASSEMBLY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5556-041" AND S/N PER QSI 044 6.2 (X-TENSION STAMP)
- 7) WEIGHT: 3.82 lbs
- 8) APPLY LOCTITE 598 (RTV SEALANT) TO ALL FAYING SURFACES UPON ASSEMBLY

RELEASED

2018 MAR 09
ECN 18-600



REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	17.11.14
DESIGN	AJS	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5556	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	CP	UPPER CUTTER ASSEMBLY (EC 130)	NTS
DATE	17.11.14	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED